

Work Order ID 153457

Monday, November 21, 2016 9:22:48 AM

153457

Page 1

Item ID: D3508-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Aft Center
 Start Date: 11/15/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/21/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **NOV 22 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3508	Rev C								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg D3508 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS 38 9-89
NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00			DAS 30 9-89	(2)			NOV 28 2016
130 Brake NC	Memo	0.01							
Brake NC	1-Form on brake using DT8326 and DT8261as per Dwg D3508								
140	QC5- Inspect part completeness to step on W/O	0.00				2			DAS 38 9-89 NOV 28 2016
140 QC	Memo	0.01							
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				2	φ	16-11-30	DAS 34 9-89
150 Powdercoat	Memo	0.01							
Powder Coating	START TIME: 1:30 FINISH TIME: 2:00 OVEN TEMPERATURE:								

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
3A-1 QC 3A-2								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
								Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
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Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
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Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐							
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160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.03							
Quality Control									

MF 16-12-01
 ②
 DAS 11 9-89
 2 DAS 6 9-89 DEC 05 2016
 DAS 21 9-89 DEC 05 2016
 16-12-05

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Picklist Print

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Parent Item: D3508-11

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Parent Item Name: Wearplate Aft Center

Start Date: 11/15/2016

Required Date: 11/21/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	125.3210	0.5887	1.239368			

M304S20GA

304/316 .040 Sheet

due 11/25

Location

Loc Qty

Loc Code

MAT020

124.5

m134495

0.2

m134982

0.1

m135327

71.7

m135689

52.5

MAT20

0.821

m133901

0.821

1.3

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Work Order update only ☐

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Description Work Order Deviation			Disposition																																																																												
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DART AEROSPACE LTD		Work Order:	153457
Description: Wearplate		Part Number:	D3508-11
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

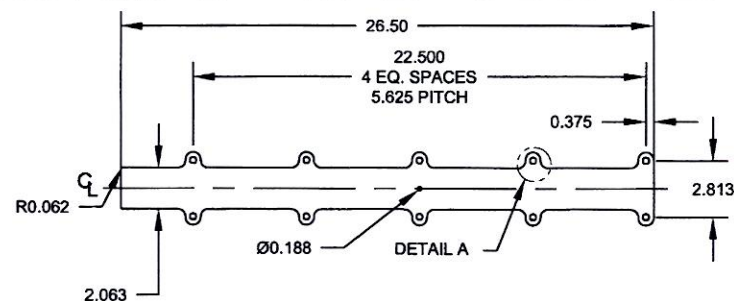
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

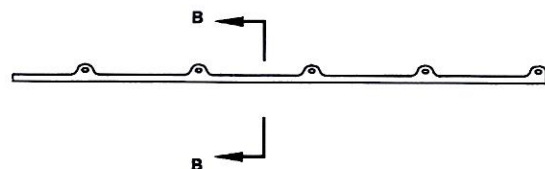
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2.813	+/-0.010	2.809	1		Top	
0.375	+/-0.010	.370	1			
5.625	+/-0.010	5.621	1			
22.500	+/-0.010	22.500	1			
26.50	+/-0.030	26.50	1			
Ø0.188	+0.005/-0.001	Ø.189	1			
0.300	+/-0.010	.299	1			
0.300	+/-0.010	.300	1			
0.038	+/-0.010	.036	1			

Measured by:	DR	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	11/11/25	Date:	NOV 25 2016	Date:	N/A

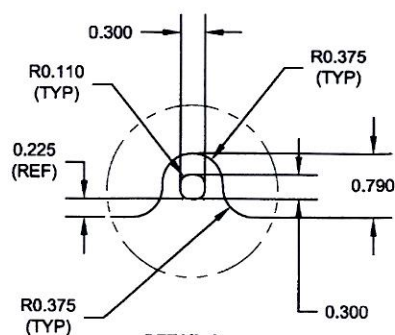
Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	DA



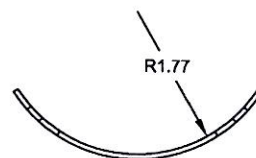
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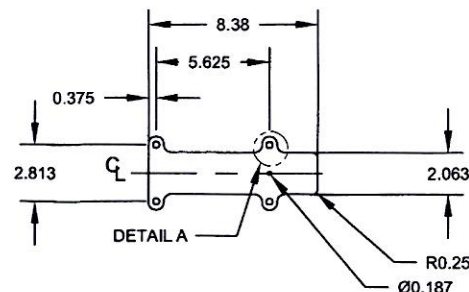
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(MAKE FROM D3508-11F)



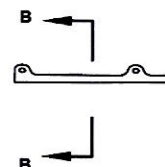
DETAIL A
(SCALE 2:3)



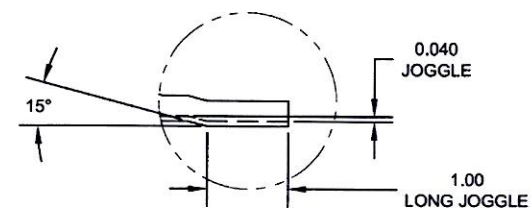
SECTION B-B
(SCALE 2:3)



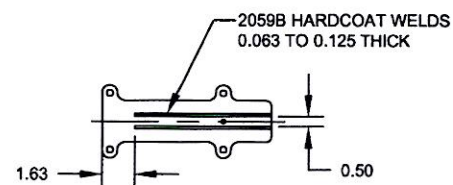
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153457 MJS
16-11-22

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	B	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	